

Cooling

Tolerance f8

Coating BetaUni Iron

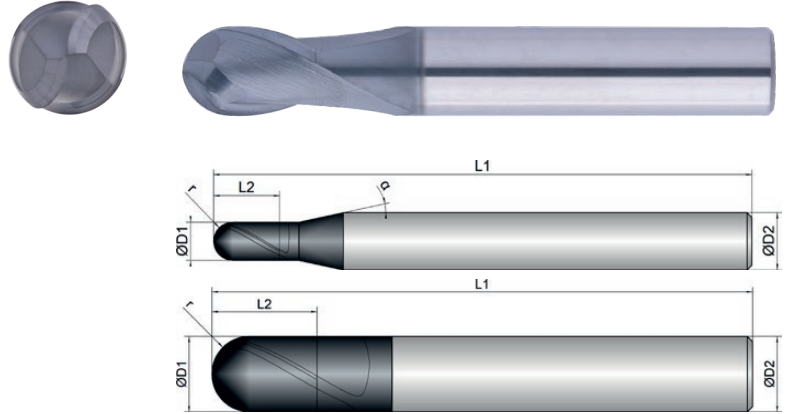
Strategy **HSC** **UNI**

Application

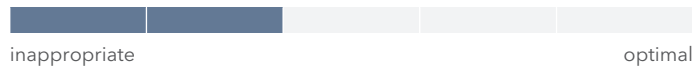
Features **HA**

Basic

- Geometry of the face cutting edge designed for a soft and even cut
 - Adapted chip chambers for roughing and finishing
-
- Suitable for wet and dry machining
-
- Short version



Roughing



Finishing



BCU1-M08-0053	D1 mm ∅	L2 mm	L1 mm	D2 mm ∅	z #	r mm		α °
0,5	0.5	1.5	57.0	6.0	2	0.25	30	12
1	1.0	2.0	57.0	6.0	2	0.50	30	12
1,5	1.5	3.0	57.0	6.0	2	0.75	30	12
2	2.0	4.0	57.0	6.0	2	1.00	30	12
2,5	2.5	5.0	57.0	6.0	2	1.25	30	12
3	3.0	6.0	57.0	6.0	2	1.50	30	12
4	4.0	7.0	57.0	6.0	2	2.00	30	12
5	5.0	8.0	57.0	6.0	2	2.50	30	12
6	6.0	10.0	57.0	6.0	2	3.00	30	0
8	8.0	12.0	63.0	8.0	2	4.00	30	0
10	10.0	14.0	72.0	10.0	2	5.00	30	0
12	12.0	16.0	83.0	12.0	2	6.00	30	0



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		Dimension	Ø 0.5	Ø 1	Ø 1.5	Ø 2	Ø 2.5	Ø 3	Ø 4	Ø 5	Ø 6	Ø 8	
		Infeed in mm	ae=0.05xD ap=0.05xD	ae=0.05xD ap=0.05xD	ae=0.05xD ap=0.05xD	ae=0.05xD ap=0.05xD	ae=0.05xD ap=0.05xD	ae=0.05xD ap=0.05xD	ae=0.05xD ap=0.05xD	ae=0.05xD ap=0.05xD	ae=0.05xD ap=0.05xD	ae=0.05xD ap=0.05xD	
		Application											
Material	Strength (N/mm ²)	Feed (mm/Z)	fz	fz	fz	fz	fz	fz	fz	fz	fz	fz	
P		Vc (m/min)											
1.1-1.3	Steel, unalloyed	<850	290	0.01	0.02	0.03	0.04	0.045	0.05	0.06	0.07	0.085	0.12
2.1-2.2	Steel, low-alloyed	<950	240	0.008	0.015	0.025	0.035	0.04	0.045	0.055	0.065	0.08	0.11
3.1-3.2	Steel, high-alloyed	<1100	230	0.006	0.012	0.022	0.03	0.035	0.04	0.05	0.06	0.075	0.09
K		Vc (m/min)											
1.1-1.2	Grey cast iron	<1000	300	0.008	0.015	0.025	0.035	0.045	0.05	0.055	0.065	0.08	0.11
M		Vc (m/min)											
1.1	Inox, ferritic/martensitic	<850	100	0.01	0.015	0.02	0.025	0.03	0.035	0.045	0.05	0.06	0.075
2.1	Inox, austenitic	<650	85	0.008	0.012	0.015	0.02	0.025	0.03	0.04	0.045	0.055	0.07
N		Vc (m/min)											
1.1-2.3	Alu, alloyed, casted	<600	500	0.01	0.015	0.018	0.02	0.022	0.025	0.03	0.05	0.06	0.07
3.1-3.3	Cooper, alloyed	<600	220	0.006	0.008	0.012	0.015	0.018	0.02	0.024	0.04	0.05	0.06
T		Vc (m/min)											
2.1-2.2	Titanium, pure, alloyed	<1000	50	0.008	0.012	0.012	0.015	0.015	0.018	0.022	0.025	0.03	0.04
S		Vc (m/min)											
1.1-1.3	Super alloys	<1450	30	0.006	0.01	0.01	0.012	0.012	0.015	0.018	0.02	0.025	0.035

		Dimension	Ø 10	Ø 12								
		Infeed in mm	ae=0.05xD ap=0.05xD	ae=0.05xD ap=0.05xD								
		Application										
Material	Strength (N/mm ²)	Feed (mm/Z)	fz	fz								
P		Vc (m/min)										
1.1-1.3	Steel, unalloyed	<850	290	0.13	0.14							
2.1-2.2	Steel, low-alloyed	<950	240	0.12	0.13							
3.1-3.2	Steel, high-alloyed	<1100	230	0.1	0.11							
K		Vc (m/min)										
1.1-1.2	Grey cast iron	<1000	300	0.12	0.13							
M		Vc (m/min)										
1.1	Inox, ferritic/martensitic	<850	100	0.09	0.1							
2.1	Inox, austenitic	<650	85	0.08	0.09							
N		Vc (m/min)										
1.1-2.3	Alu, alloyed, casted	<600	500	0.08	0.09							
3.1-3.3	Cooper, alloyed	<600	220	0.065	0.075							
T		Vc (m/min)										
2.1-2.2	Titanium, pure, alloyed	<1000	50	0.055	0.065							
S		Vc (m/min)										
1.1-1.3	Super alloys	<1450	30	0.045	0.055							

NOTE | The values marked in turquoise are side applications!